

Date: Friday, 19/10/2007 2:56:25 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR AFT RH
Job Number : 35249	
Estimate Number : 11235	
P.O. Number :	Part Number : D32814
This Issue : 19/10/2007 S.O. No. :	Drawing Number : D3281 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 18/10/2007 Type : THERMOFORMING	Drawing Revision : B
Previous Run : 35085	Material :
Written By :	Due Date : 25/10/2007 Qty: <u>4</u> Um: Each
Checked & Approved By :	
Comment : Est Rev:A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

PG

PURCHASING

**Comment:** PURCHASINGIssue P/O: 4865

Description: Floor Protector Aft, RH

Possible Supplier: Delastek

Certificate of Conformity is required

C207/10/22

2.0

D32814P

Floor Protector, Aft RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Floor Protector Aft, RH

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

C21/10/25 (4)

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

C21/10/23 (4)

5.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: ST266(4X) 07/10/30 AS.CU

Date: Friday, 19/10/2007 2:56:25 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR AFT RH

Job Number: 35249

Part Number: D32814

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



07.10.31 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

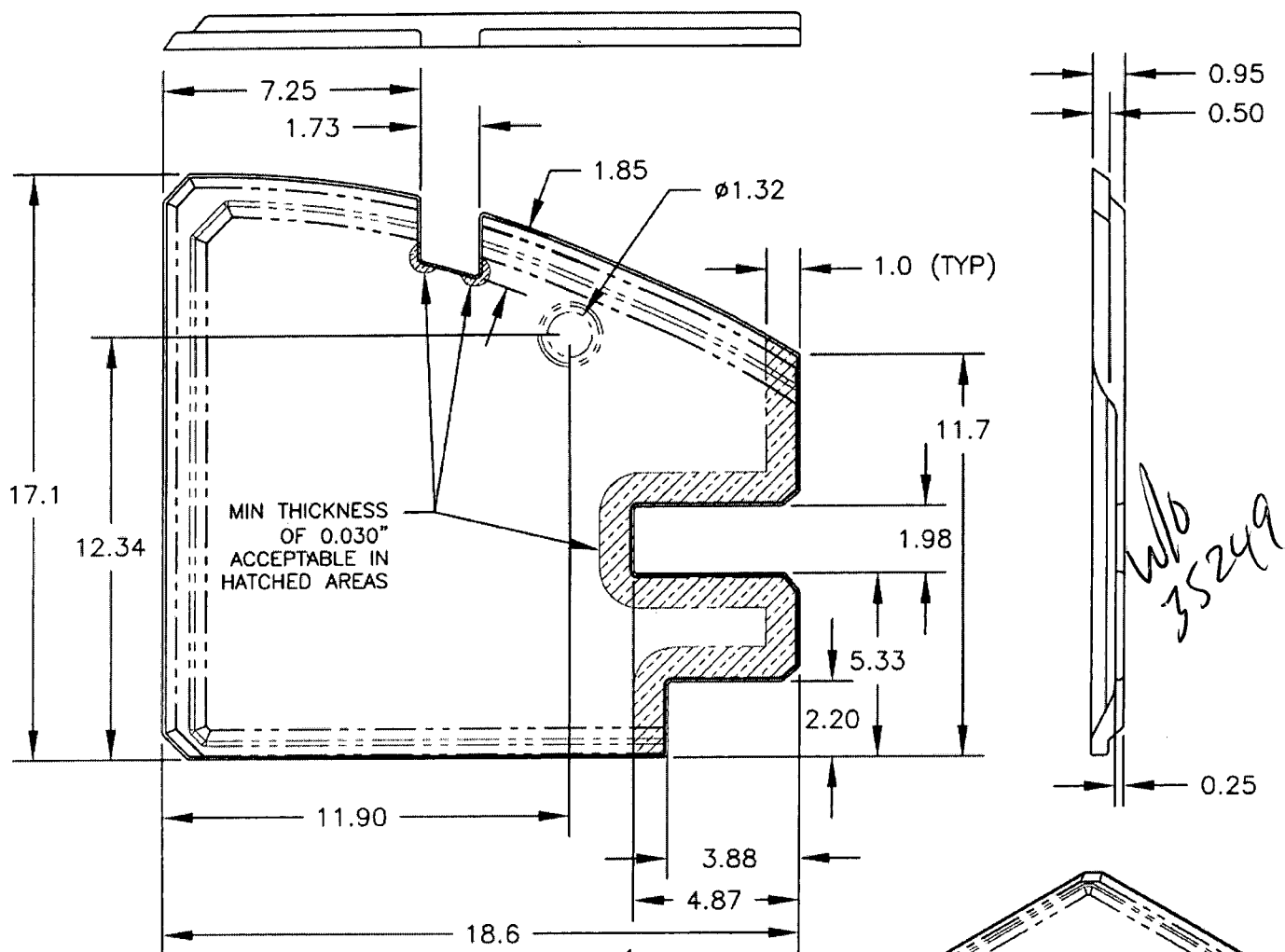
Job Completion



Le 07.10.31



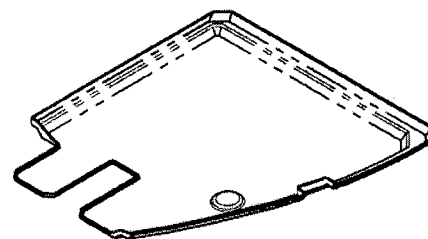
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	



RELEASED
05.12.01

UNDER REVIEW

07.10.05 LE
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 35249

D3281-1 FLOOR PROTECTOR, FWD LH

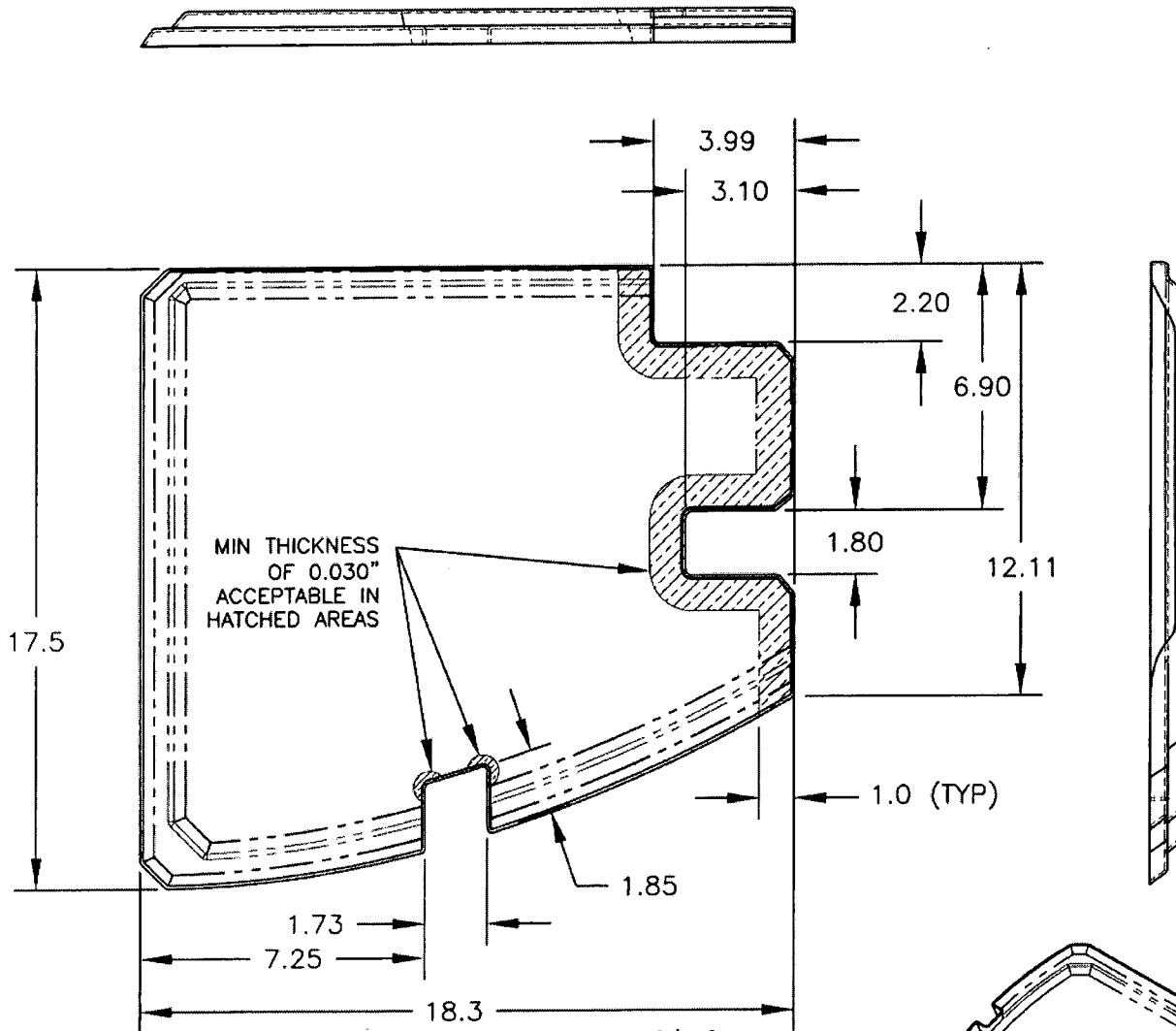
- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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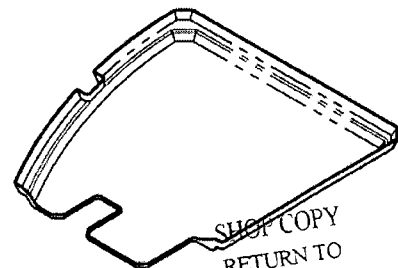
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5



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05.12.01

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NO. 35249

D3281-2 FLOOR PROTECTOR, FWD RH

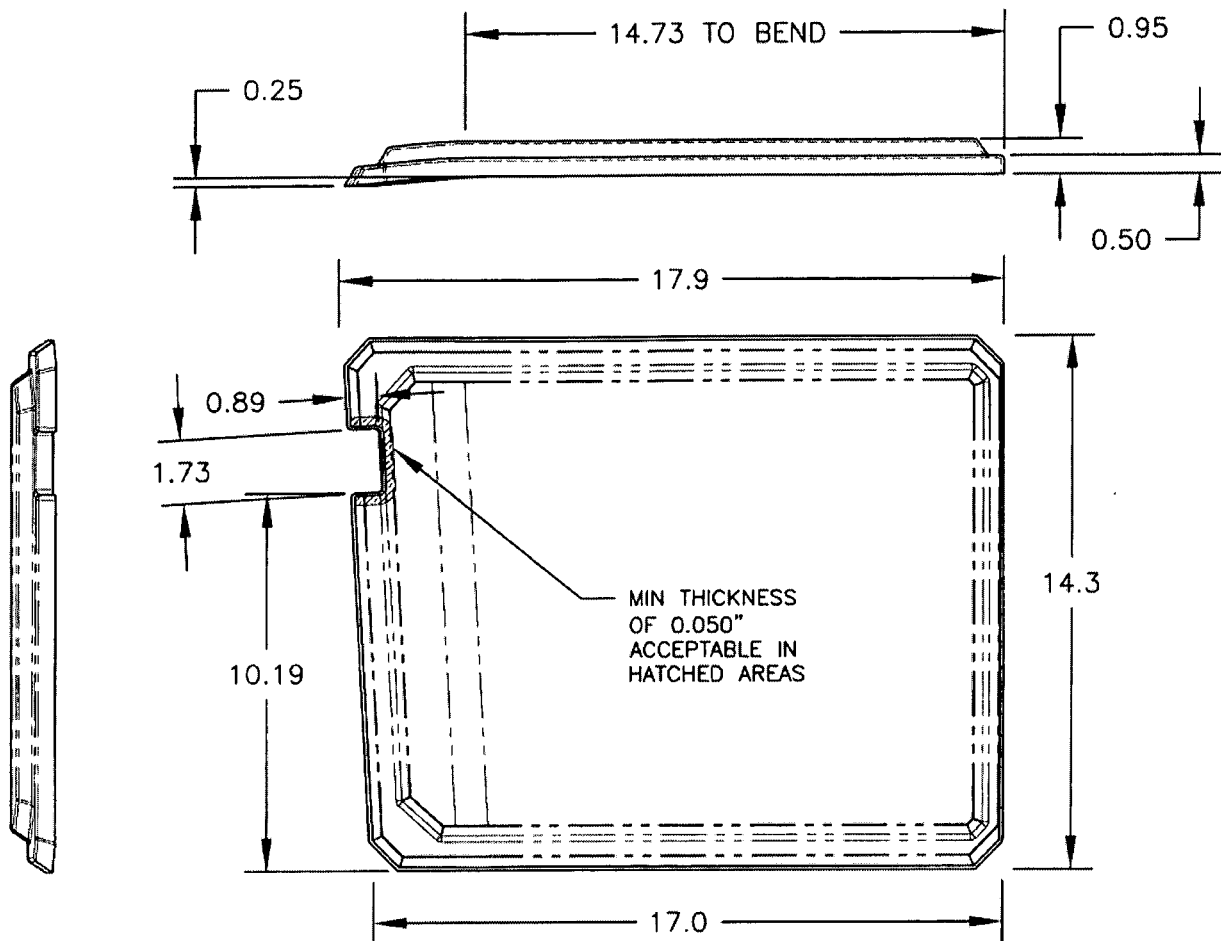
- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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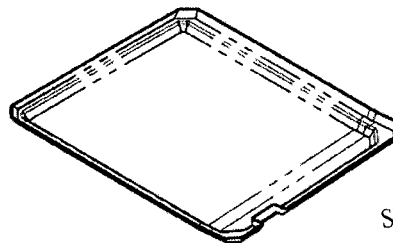
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5



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05.12.01

UNDER REVIEW

07.10.05 LE
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AND SHIP



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25249

D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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ale: Jeudi, 2006-11-16 15:07:40
utilisateur: Sylvie Hamel

Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : FLOOR PROTECTOR AFT, LH
Numéro Job : 40357		Numéro Article : DKC134-0047
Numéro Soumission : 2386		Numéro Dessin : D3281
Numéro B.A. :		Projet Numéro : DKC134
Cette fois : 2006-11-16	No. B.V. :	Révision dessin : B
Prsht Rev. : NC		Matériel : F6006
Rem. fois : -	Type :	Date Due : 2006-12-08
Job précédente : 36895		Qté: 16
		Unité: UNITE

Écrit par : _____
Vérifié & Approuvé par : _____
Commentaires : N° de pièce: D3281-4

Process Sheet Rév.: 00 Création du premier

Produit additionnel

Numéro Job:



Séq.:

Machine ou Opération:

Description :

1.0

APL0016

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Commentaire Qty.: 0.167 UNITE(s)/Unit Totr'
Lexan F6006 Noir N° 700 48" x 96"

APL0016



3-5913-1

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

N° de Lot: _____

Bon achat: 5913

2.0

SÉCHAGE/ ANEAL



Commentaire Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.5000Hrs
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

de cuisson: 5484

3.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 45.0000Hrs
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 25 Date: 11-1-07 Sceau:



Quantité: _____ Date: _____ Sceau: _____

Date: Jeudi, 2006-11-16 15:07:40
Utilisateur: Sylvie Hamel

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.
Numéro Job: 40357

Nom Dessin: FLOOR PROTECTOR AFT, LH
Numéro Article: DKC134-0047

Numéro Job:



Séq.: Machine ou Opération: Description :

4.0 THERMOFORMAGE2 THERMOFORMAGE DES PIÈCE DART




Commentaire Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 2.5000Hrs
THERMOFORMAGE DES PIÈCES

Faire le thermoformage du " Floor Protector " N° D3281-4 à l'aide du moule N° D3281-4T1 sur le
thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.



Quantité: 24 Date: 11-1-07 Sceau:

PD. 
2 Aug -

Quantité: Date: Sceau:

5.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



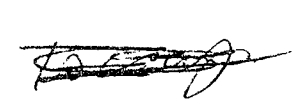
Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 2.5000Hrs
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-4 à l'aide du gabarit de trimage N° D3281-4T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 24 Date: 12-1-07 Sceau: SB




Quantité: Date: Sceau:

6.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 24 Date: 18-01-07 Sceau: 

7.0 IDENTIFICATION4 IDENTIFICATION PIÈCES DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

ate: Jeudi, 2006-11-16 15:07:40
tilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR AFT, LH

Numéro Job: 40357

Numéro Article: DKC134-0047

Numéro Job:



Séq.: Machine ou Opération: Description :

N° de pièce: D3281-4

N° de Job: 40357

Date de fabrication: 15-1-07

Sceau d'inspection.

Quantité: 24 Date: 15-1-07 Sceau: Lab

Quantité: _____ Date: _____ Sceau: _____

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs

EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton identifiée comme suit:

N° de pièce: D3281-4

Date de fabrication: _____

N° de job: _____

Quantité: 24 Date: 18/1/07 Sceau: 71

Quantité: _____ Date: _____ Sceau: _____



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12223
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
24/10/2007	22/10/2007	5510	C. LAVOIE		PO000004865		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
4	0	4	DKC134-0044	Floor Protector Fwd LH Part 1 N° D32811P B35246 U de M : Each Selon dessin D3281 Rev.: B Job: 40952			
4	0	4	DKC134-0045	Floor Protector Fwd RH Part 2 N° D32812P B35247 U de M : Each Selon dessin D3281 Rev.: B Job: 40953			
4	0	4	DKC134-0046	Floor Protector Aft LH Part 3 N° D32813P B35248 U de M : Each Selon dessin D3281 Rev.: B Job: 40954			
4	0	4	DKC134-0047	Floor Protector Aft RH Part 4 N° D32814P B35249 U de M : Each Selon dessin D3281 Rev.: B Job: 40957			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Paul St. Louis
Quality department
AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.